

Work Order ID 59102

Page 1

Wednesday, May 26, 2010 12:30:19 PM

Item ID: D4035-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Rib Assembly, Aft (350 Basket)

Start Date: 5/26/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 5/31/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start

Approvals: Process Plan: *11*Date: *10-3-26*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	Memo	0.00	0.00	0.00	0.00	0.00	0.00	0.00
D4035	A								
100		Weld per dwg A/R S.S. rod Batch: <i>1113328</i>	0.00						



Large Fab

Memo

Large Fab

- 1- Cut D4035-3 as per dwg D4035
- 2- Drill holes using DT9563 and chamfer holes as per dwg D4035
- 3- remove identification marks and deburr *SAD* *10-06-03*
- 4- Weld bushing in rib and grind weld flush as per dwg D4035 *10-06-03*

(2) *SM* 10/06/03

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
QC	Memo	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00

Quality Control

(1) *10-06-03*

W/O:		WORK ORDER CHANGES					
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Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

(2) PD 10.06.03

130

Identify as per dwg & Stock Location:

0.00



Packaging

Packaging

Basket coll

Memo

M 10/06/03 (2)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

10/06/04 JJ

MF
10-6-4

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Picklist Print

Wednesday, May 26, 2010 12:30:24 PM

Page 1

Work Order ID: 59102



Parent Item: D4035-043



Parent Item Name: Lid Rib Assembly, Aft (350 Basket)

Start Date: 5/26/2010

Required Date: 5/31/2010

Comments: IPP revA: new issue DD 09.11.25 verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4021-9		Manufactured	No			100	Each	28.0000	2	4		AM 10/06/03	

Bushing

M304TS0.750W.049	Purchased	No	<u>Location</u>		Loc Qty	Loc Code	Total Qty	Qty Issued	Date Issued
			WA						
			56094		2				
			58404		10			⑦	

304 SQ Tube .75x.75x.049W

M304TS0.750W.049	Purchased	No	<u>Location</u>		Loc Qty	Loc Code	Total Qty	Qty Issued	Date Issued
			MAT						
			113763		0				
			114323		33.2519289			3.6842	
			114677		176.40685				
			MAT017		3.68448E-05				
			114298		3.6845E-05				

SAD 10-06-03

3.6842

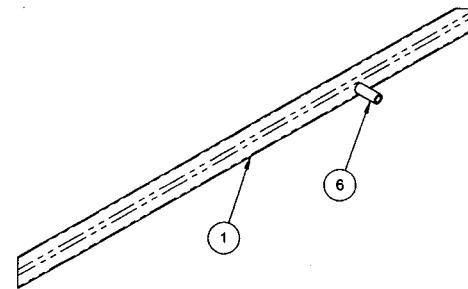
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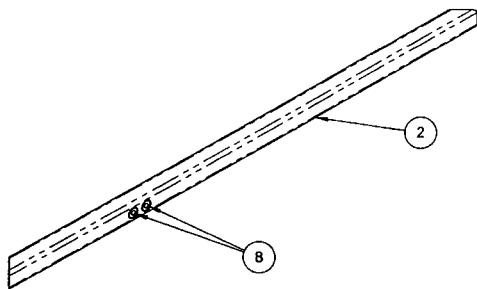
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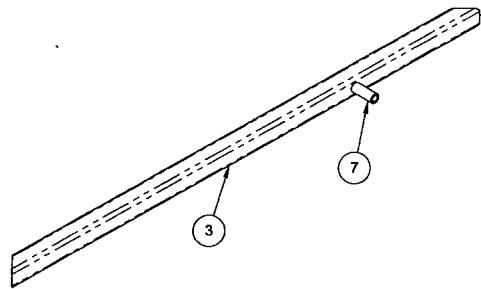
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7		1			D2953-175	SPACER
8		2			D4021-9	BUSHING



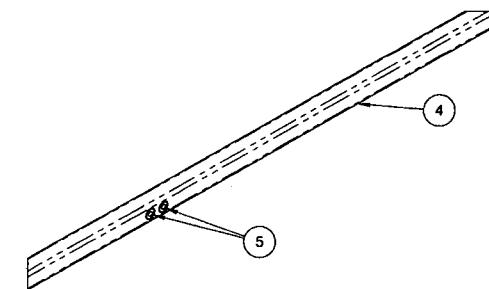
D4035-041 BASKET LID RIB ASSY, FWD



D4035-043 BASKET LID RIB ASSY, AFT



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)



D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
2010-03-12
AM

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ENGINEERING

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 59102

A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION			BY DATE
DESIGN	AJS		DART AEROSPACE LTD	
DRAWN	JPH		HAWKESBURY, ONTARIO, CANADA	
CHECKED			DRAWING NO.	REV. A
MFG. APPR.			D4035	SHEET 1 OF 5
APPROVED	W		TITLE	SCALE
DE APPR.	W		BASKET LID RIB ASSY	NTS
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BF-03-26

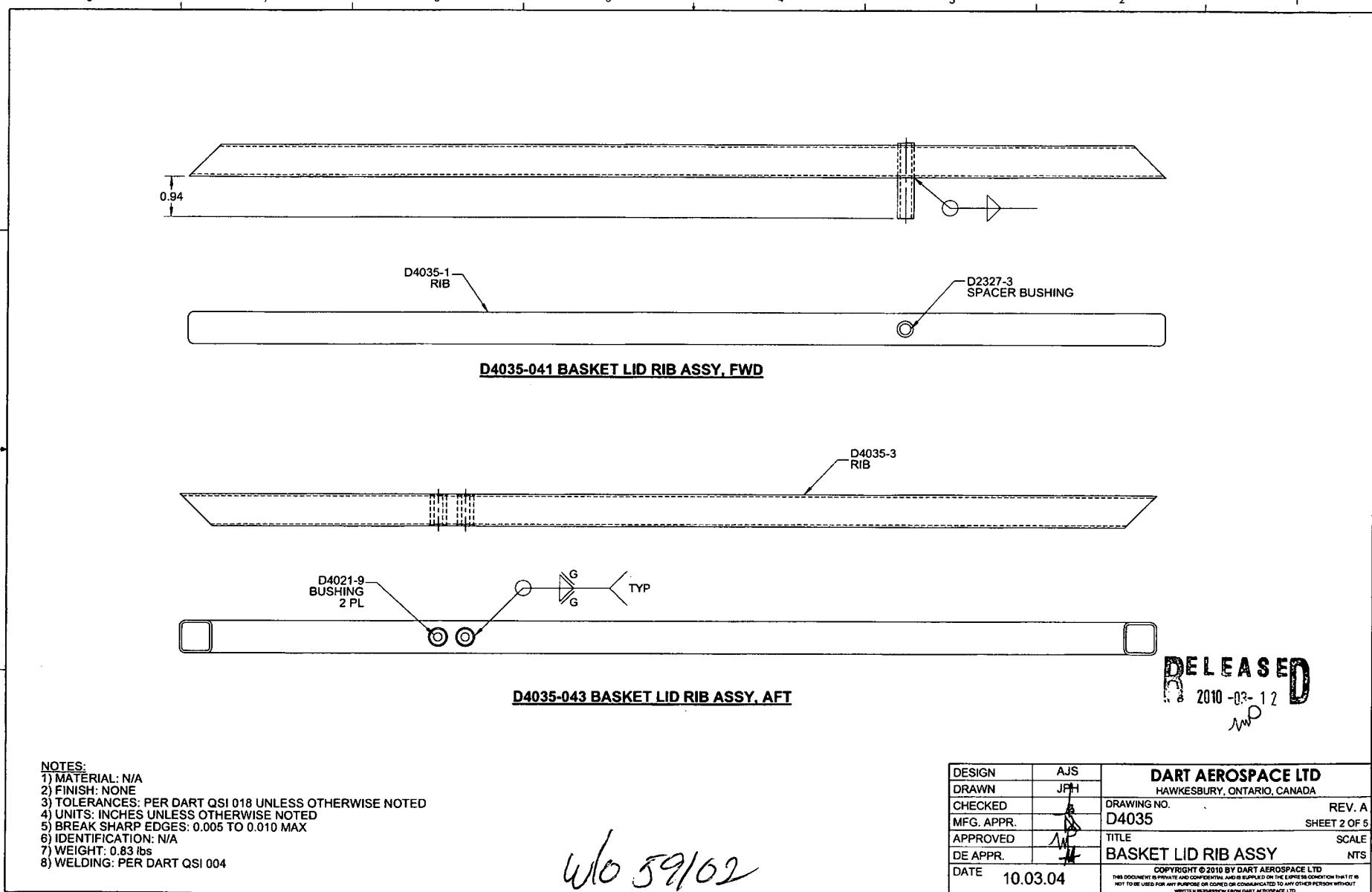
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CHECKED		DRAWING NO.	
MFG. APPR.		REV. A	
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DE APPR.		SHEET 2 OF 5	
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8 | 7 | 6 | 5 | 4 | 3 | 2

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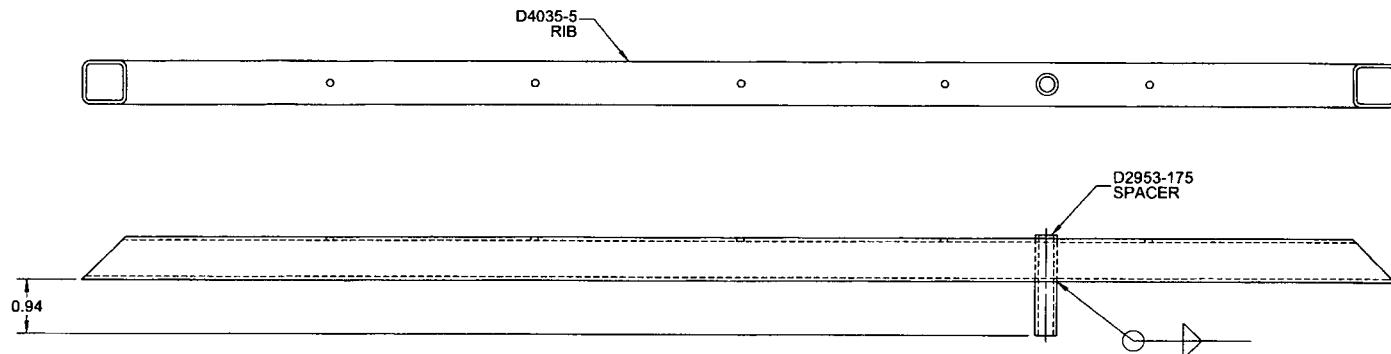
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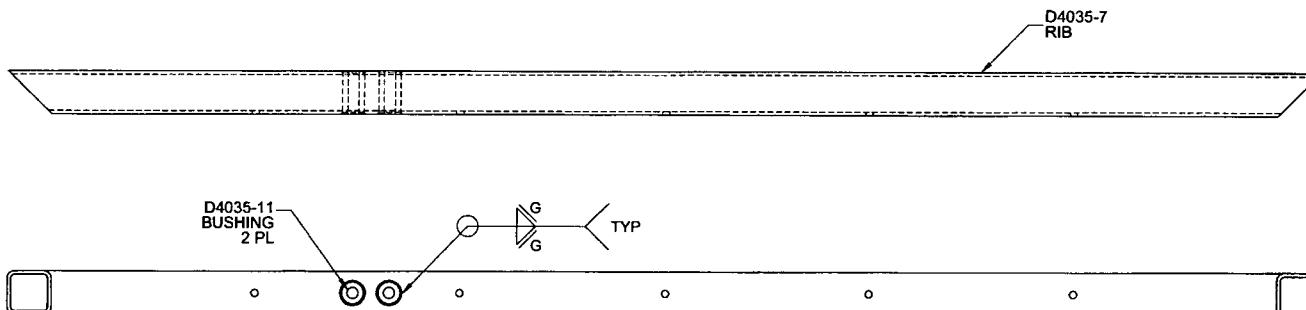
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8

1



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)



D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
2010-03-12
[Signature]

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.34 lbs
8) WELDING: PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKSBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED	<i>[initials]</i>	DRAWING NO.	REV. A	
MFG. APPR.	<i>[initials]</i>	D4035	SHEET 3 OF 5	
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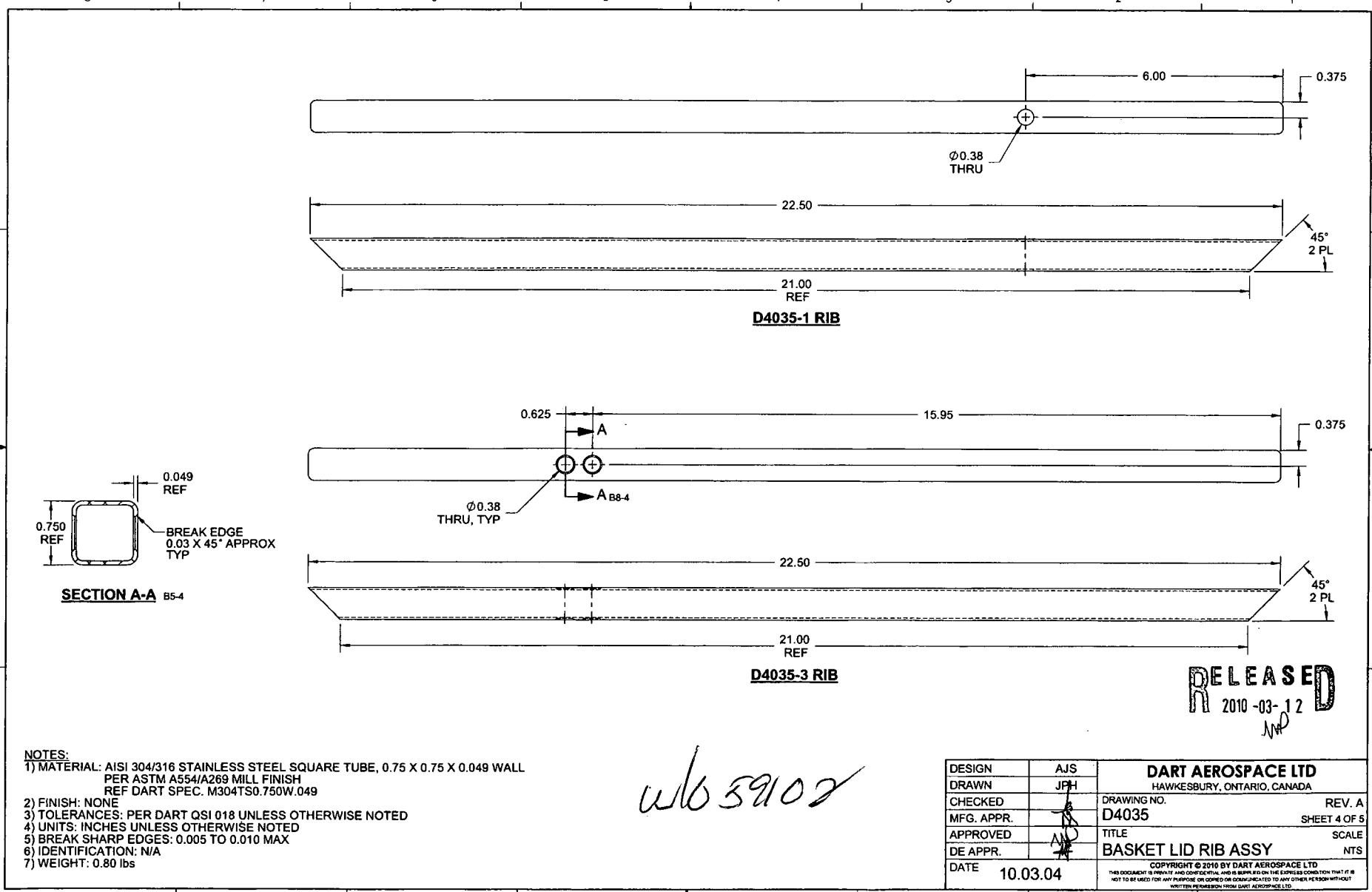
8 7 6 5 4 3 2 1

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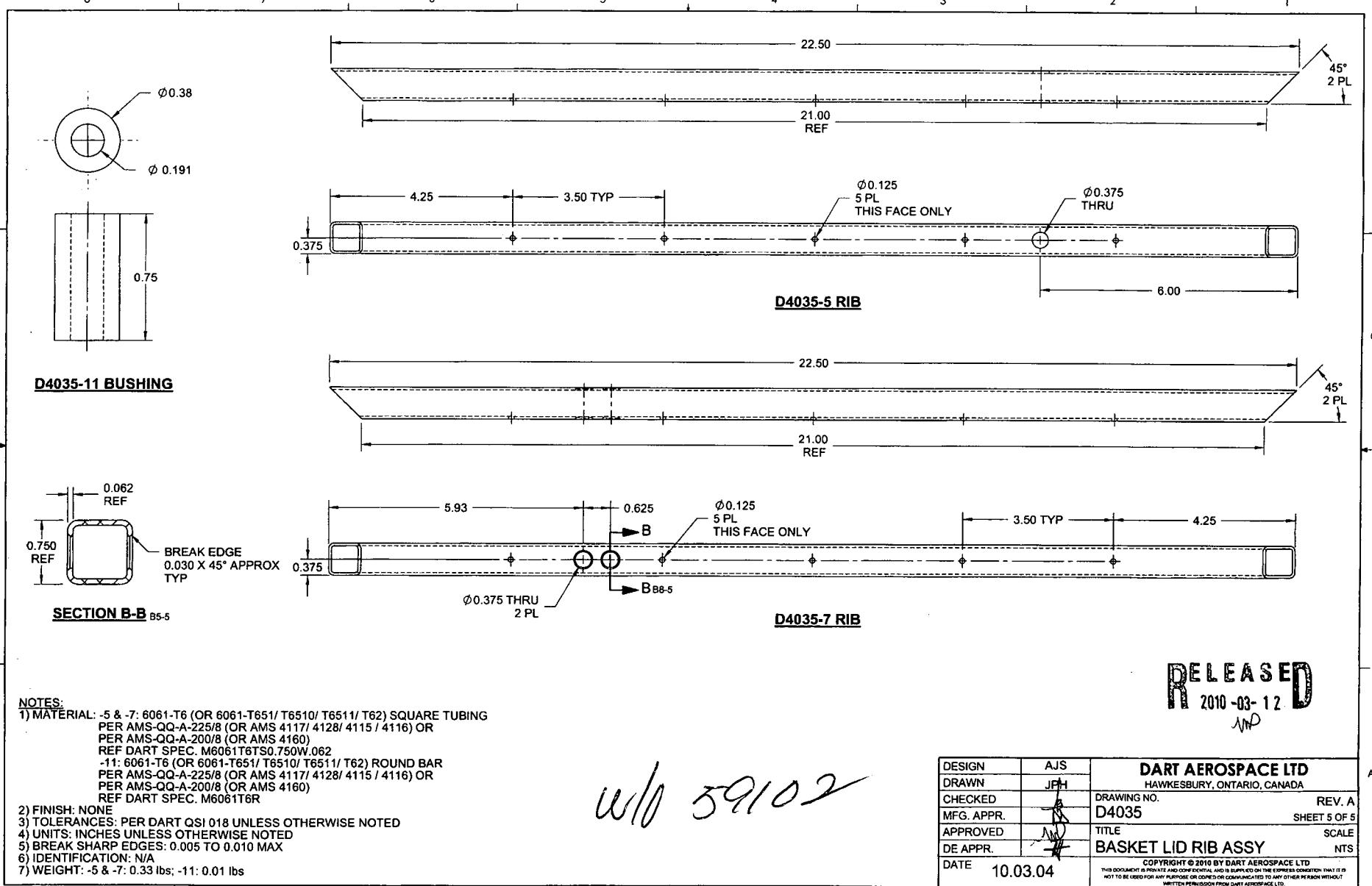
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